

Date: Sunday, 12/4/2005 12:45:08 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP LEG
Job Number :	25089B		
Estimate Number :	10353		
P.O. Number :	N/A	Part Number :	D2278
This Issue :	12/4/2005	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2278 REV D
First Issue :	N/A	Project Number :	N/A
Previous Run :	24533B	Drawing Revision :	D
	Type :	Material :	N/A
		Due Date :	12/12/2005
Written By :	See comment below		Qty: 40 Um: Each
Checked & Approved By :	See comment below		
Comment :	Est Rev:A New Issue 05-11-07 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 1.0306 sf(s)/Unit Total: 41.2230 sf(s)
 Material: 5052-H32 sheet (QQ-A-250/8) 0.080" Thick
 (M5052H32S.080)
 Identify as D2278
 Batch: M19052

2.0	SHEAR	SHEAR J.L	05.12.10 40
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Comment: SHEAR
 Cut blanks: (16.61" x 8.51") +.000/-0.020" (grain along 8.51") for each leg

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 J.L	05.12.10 40
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2278, use stack of 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE J.L	05.12.10 40
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

9m 05/12/10 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 9 Date: 05/12/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

SAD 118/12/05/40

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

SAD 118/12/05/40

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5-12-19

40

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA

SB 05/12/19

40

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

545 05/12/21 (40)

SB 05/12/21

40

Job Completion



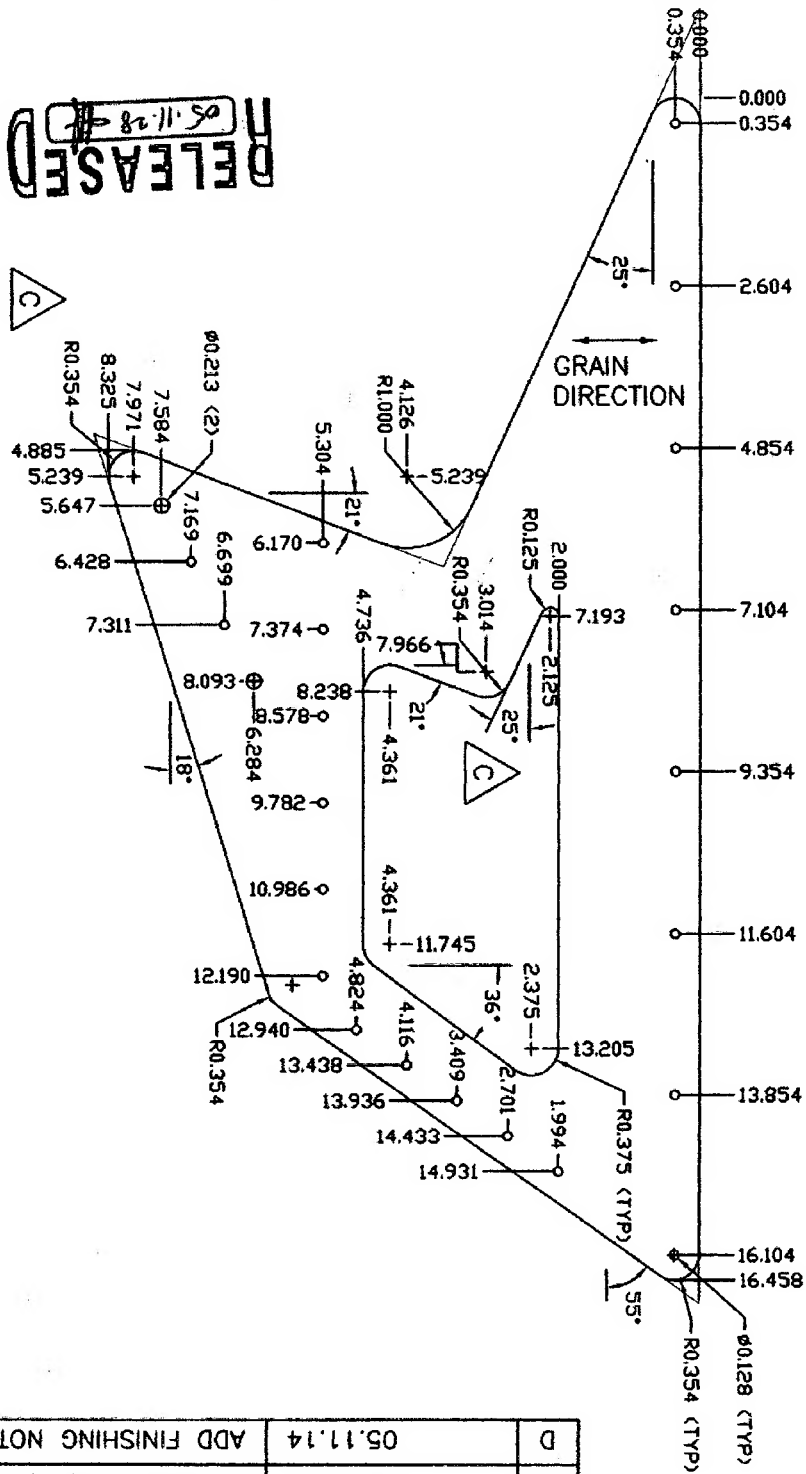
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED



- D2278 LEG
- 1) MATERIAL: 5052-H32 ALUMINUM SHEET (QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC M5052H32S.080)
 - 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	CHECKED	APPROVED	DRAWING NO.	D2278	REV. D	SHEET 1 OF 1	SCALE	1:2.5
DATE	05.11.14	TITLE	LEG	ADD FINISHING NOTE	CHANGED RADIUS TO 0.354	D	05.11.14	ADD FINISHING NOTE	



DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

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